

Work Order ID 56529

March 1, 2010 9:30:08 AM

Page 1

Item ID: D2857-1

Accept

Setup Start

Revision ID:

Stop

Item Name: Hinge Bracket

Start Date: 3/01/10

Start Qty: 24.00

Cust Item ID:

Required Date: 3/08/10

Req'd Qty: 24.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2857

Rev B

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

Cut blanks 5.2"

B.A 10/03/01

19

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine per folio D2857-11 12-Deburr any rough edges

B.A 10/03/04

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

B.A 10/03/04
10.3.6

19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 56529

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Item ID: D2857-1

Accept



Setup Start



Revision ID:

Stop



Item Name: Hinge Bracket

Start Date: 3/01/10 Start Qty: 24.00



Cust Item ID:

Required Date: 3/08/10 Req'd Qty: 24.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

S.F. 10/03/08

19

Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

M 10/03/08

(X19)

6

Hand Finishing

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

S 10/03/08

(719)

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____








NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			




NOTE: Date & initial all entries

Work Order ID 56529

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Item ID:	D2857-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Hinge Bracket					
Start Date:	3/01/10	Start Qty:	24.00		Cust Item ID:	
Required Date:	3/08/10	Req'd Qty:	24.00		Customer:	
Reference:						
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start
	QC:	Date:	SPC (Y/N):	Date:		Stop
						
						

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum <i>M/113170</i> Memo START TIME: <i>10:30AM</i> OVEN TEMPERATURE: <i>11:00AM</i> FINISH TIME: <i>320°F</i>	0.00 0.00		<i>⇒ M/10/03/10</i>		<i>(19)</i>	<i>φ</i>		
170  QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00		<i>BR 10-3-10</i>		<i>(19)</i>	<i>φ</i>		
180  Packaging Packaging	Identify as per dwg & Stock Location: <i>26</i> Memo	0.00 0.00						<i>P/10/3/11</i>	<i>(19)</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

March 1, 2010 9:30:08 AM

Page 1

Work Order ID: 56529

Parent Item: D2857-1

Parent Item Name: Hinge Bracket

Comments: IPP [C]100.06.22[]Removed P/O for powder coat[]EC[]
IPP [D]106.05.01[]Added level 8[] EC[]

Start Date: 3/01/10

Required Date: 3/08/10

Start Qty: 24.00

Required Qty: 24.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6B2.000X01.25 0		Purchased	No			100	f	27.5655	11.0526			



6061-T6 Bar 2.00 x 1.25



<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	27.56546842	
105838	6.9124	
110936	0.00036842	
113608	20.6527	

9.1000 ft

H.A 10/03/01

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 36529
Description: Hinge Bracket		Part Number: D2857-2
Inspection Dwg: D2857 Rev: B		Page 1 of 1


FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.300	+/-0.010	4.309	✓			
4.000	+/-0.010	4.009	✓			
0.340	+/-0.010	0.340	✓			
1.110	+/-0.005	1.113	✓			
1.790	+/-0.010	1.792	✓			
1.320	+/-0.005	1.320	✓			
2.000	+/-0.010	2.001	✓			
0.340	+/-0.010	0.342	✓			
0.447	+/-0.010	0.444	✓			
Ø0.171	+0.005/-0.000	Ø0.173	✓			
0.147	+/-0.010	0.147	✓			
0.376	+/-0.010	0.375	✓			
0.126	+/-0.010	0.127	✓			
0.063	+/-0.010	0.063	✓			
Ø0.166	+0.005/-0.000	Ø0.167	✓			
0.911	+/-0.010	0.916	✓			
0.600	+/-0.010	0.600	✓			
0.125	+/-0.010	0.133	✓			
0.150	+/-0.010	0.151	✓			

Measured by: B.A	Audited by: L.B	Prototype Approval:	N/A
Date: 10/01/04	Date: 10/03/08	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.15	New Issue	KJ/JLM	
B	07.04.20	Dimensions update per Dwg Rev B	KJ/JLM	

DESIGN KE	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED PH	APPROVED 	DRAWING NO. D2857	REV. B SHEET 1 OF 1
DATE 06.08.28		TITLE HINGE BRACKET	SCALE 1:1
REV	DATE	DESCRIPTION	
A	98.12.14	NEW ISSUE	
B	06.08.28	ADD THICKNESS, REDRAW W/ SOLIDWORKS	